

Work Order ID 150199

Wednesday, August 24, 2016 11:51:07 AM

Page 1

U/R

150199

Item ID: D412-705-015

Revision ID: URF 16-530

Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016 Start Qty: 1.00

Required Date: 8/31/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

1

1

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 25 2016** Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-750	E U/R OK 16/5/12							DAS 21 9-89	16-10-25
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-705-015		CHG 005	006					
								DAS 28 9-89	OCT 25 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
								DAS 27 9-89	OCT 25 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
								DAS 28 9-89	OCT 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

Work Order ID 150199

Wednesday, August 24, 2016 11:51:07 AM

150199

Page 2

Item ID: D412-705-015

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-530

Stop

NS2

Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-705-015
Location : FG027

2x

DAS
28
9-89

OCT 25 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.02

DAS
21
9-89

OCT 25 2016

DAS
21
9-89

OCT 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Wednesday, August 24, 2016 11:51:09 AM

Page 1

Work Order ID: 150199

150199

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016

Required Date: 8/31/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Manufacturing 06-10-03 JLM
IPP Rev:C ECN 1052 07-11-05 DD verified by:EC
ECN 12-670 12.11.07 DD Verified by:JLM

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C3A Purchased No

110 Each 192.0000

22

22 44

AN3C3A

Bolt

**

OCT 25 2016

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	66	
m134055	66	
ST350	126	
m135058	10	
m135127	116	

44/

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
12240 8 1-2					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Part Exam Data ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			

Picklist Print

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Page 2

Work Order ID: 150199

150199

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016

Required Date: 8/31/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

110

Each

1,584.000

3

3-6

AN3C4A

Bolt

**

OCT 25 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	20	
122814	20	
FP001	964	
M133440	7	
M134396	41	
M134509	6	
M134606	29	
M134676	44	
M134762	106	
M134861	13	
M135058	644	
M135127	22	
M135297	52	
OVER002	500	
M135127	0	
M135297	0	
M135442	500	
ST350	100	
M132317	3	
M134134	18	
M134396	79	

D3256-1

Manufactured

No

110

Each

1.0000

1

D3256-1

Panel

**

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

151834

OCT 25 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST484	1	
142302	1	

Wednesday, August 24, 2016 11:51:09 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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OTHER : _____																									

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Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016

Required Date: 8/31/2016

Start Qty: 1.00

Required Qty: 1.00

D3256-3

Manufactured No

110 Each

9.0000

1

D3256-3

Gasket

**

OCT 25 2016

DAS 27
9-89

Location

Loc Qty

Loc Code

ST486

9

129868

1

137200

8

MS20427M3-3

Purchased No

110 Each

1,436.000

44

MS20427M3-3

Rivet

**

OCT 25 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

GA

1247

m133577

271

m134738

976

ST311

189

m134738

189

MS21060-L3K

Purchased No

110 Each

121.0000

22

MS21060-L3K

Nut Plate

**

OCT 25 2016

DAS 27
9-89

Location

Loc Qty

Loc Code

GA

87

m132256

37

m135297

50

ST300

34

m134370

1

m134861

1

m135127

32

Wednesday, August 24, 2016 11:51:09 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 4

Work Order ID: 150199

150199

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/25/2016

Required Date: 8/31/2016

Start Qty: 1.00

Required Qty: 1.00

MS9321-09

Purchased

No

110

Each

142.0000

25

25 50

MS9321-09

Washer

DAS
28
9-89

Location

ST267

Loc Qty

142

Loc Code

m134676

92

m135470

50

OCT 25 2016

DAS
27
6
9-89

43
7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

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150199

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/25/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/31/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-750	F

DAS
21

OCT 25 2016

100

Document Control

0.00

100

DOCUMENT CONTROL

DAS
21
9-89

OCT 25 2016

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-705-015 CHG 006

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

REF ID: A12345

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.